

Date: Tuesday, 23/09/2008 10:22:38 AM
User: Julie Leococq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 42235
Estimate Number : 12712
P.O. Number :
This Issue : 23/09/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : SMALL /MED FAB
Previous Run : 41082
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07-02-14 JLM

Drawing Name : WEARPAD
Part Number : D35371
Drawing Number : D3537 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 05/10/2008 Qty: 50 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 0 sf(s)/Unit Total: 6 sf(s)
M304S16GA .063" 304 SS SHEET
Batch: 109057 B 8-10-6

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3537
Dwg Rev: C
Prog Rev: C

B 8-10-6

60 148

2-Deburr if necessary B 8-10-6

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

counter
508/10/16 X60

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.
2-Identify as D3537-1

B 08/10/07

60



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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

11109303, M109213

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

EL 8-11-3

(X18)

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08-11-03 (18)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-03 (18)

9.0

POWDER COATING

POWDER COATING



M106442



(18X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8-30 OF

OVEN TEMPERATURE:

320

FINISH TIME:

9-00

m-f 08/11/04

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-04

(X18)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F2-17

EL

08-11-04

(X18)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/05

Job Completion



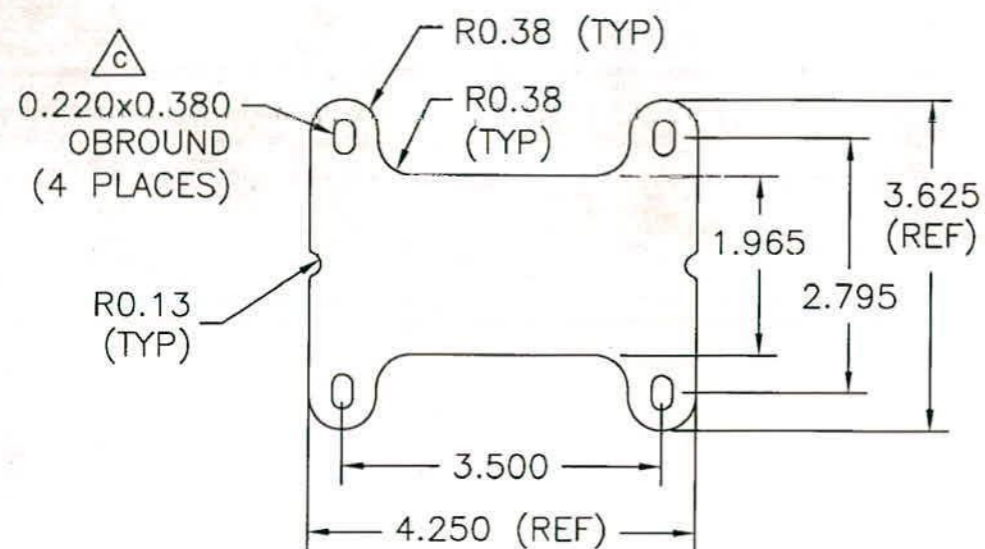
mf 08-11-04



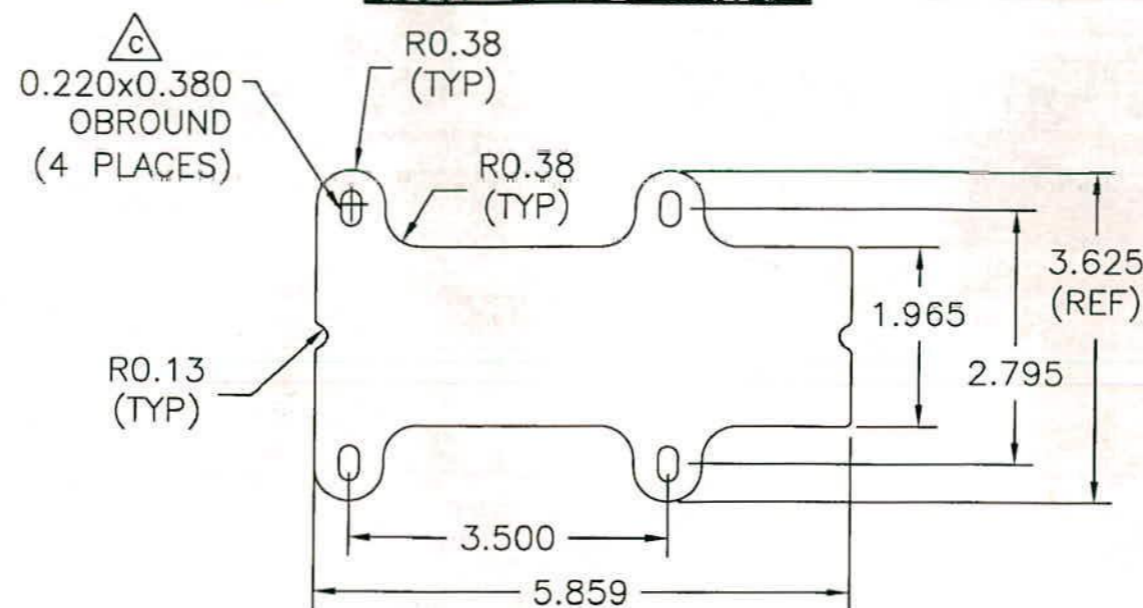
FIRST ARTICLE INSPECTION CHECKLIST



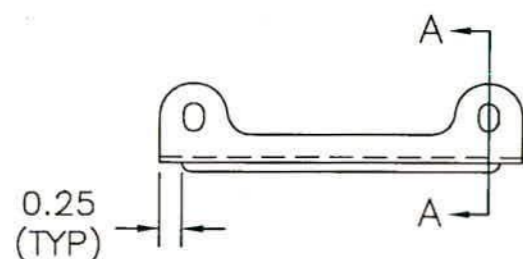
D3537-1F FLAT PATTERN



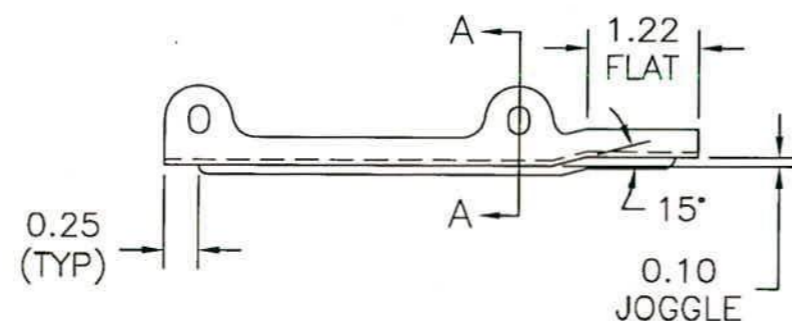
D3537-3F FLAT PATTERN



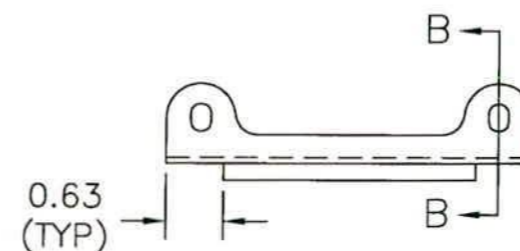
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



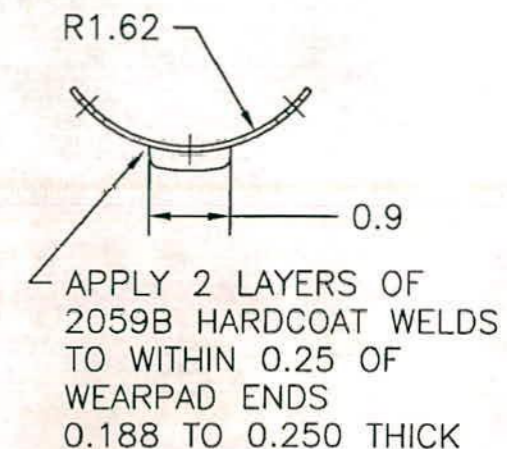
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



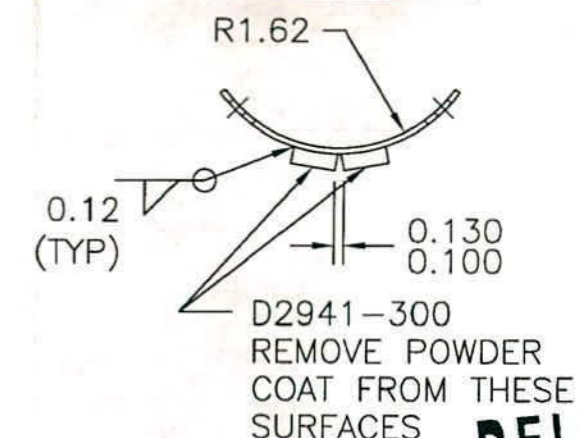
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



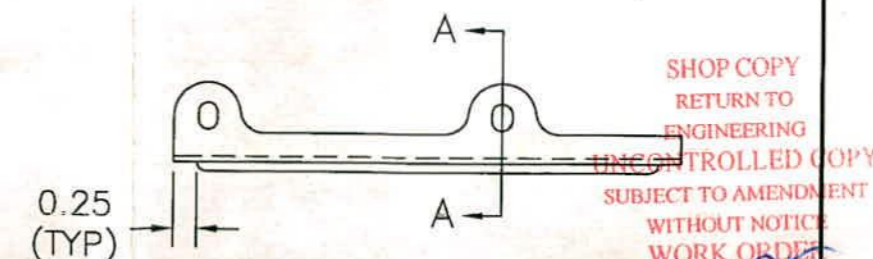
SECTION A-A



SECTION B-B



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

RELEASED
07.05.08 PH
per ELN
962

